

# Work Order ID 53124

October 22, 2009 4:23:39 PM



Page 1

Item ID: D2892-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Support

Start Date: 23/10/2009 Start Qty: 14.00



Cust Item ID:

Required Date: 30/11/2009 Req'd Qty: 14.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *RL*

Date: *09/10/22*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2892

Rev A

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA082 Tumble & Deburr

*SL/mmt*  
*09/11/03*

*13 1*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*SL/mmt*  
*09/11/03*

*13 1*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*ank 09/11/03*

*13 1*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2892-1 PAR #: \_\_\_\_\_ Fault Category: machined parts NCR: Yes No <sup>2nd NCR</sup> DQA: \_\_\_\_\_ Date: 05.11.24  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: \_\_\_\_\_ Date: 09.11.24

NCR: <u>53124</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>05.11.02</u>	<u>100</u>	HEIGHT OF TABS IS 0.030 (DWG = 0.050)	<u>UP</u> <u>05.11.02</u> <u>pc</u> <u>05.11.04</u>	Acceptable	<u>JK</u> <u>09/11/02</u>	<u>S</u> <u>02/11/04</u>	<u>UP</u> <u>05.11.02</u> <u>pc</u> <u>05.11.04</u>	<u>S</u> <u>02/11/04</u>
<u>09/11/02</u>	<u>100</u>	1 part is scrapped, engraving tool didn't raise high enough and scrapped part while turning on 4th axis, leaving a deep groove in part  R.C program error	<u>UP</u> <u>09/11/04</u> <u>05.11.02</u>	scrapped no replace Fix Proj R.1.487 WAS CHANGED TO R.1.750	<u>JK</u> <u>09/11/02</u> <u>09.11.02</u>	<u>S</u> <u>09/11/04</u> <u>05.11.04</u>	<u>UP</u> <u>09.11.04</u> <u>05.11.04</u>	<u>S</u> <u>02/11/04</u>

NOTE: Date & initial all entries

# Work Order ID 53124

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Item ID: D2892-1

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Stop



Item Name: Support

Start Date: 23/10/2009 Start Qty: 14.00



Cust Item ID:

Required Date: 30/11/2009 Req'd Qty: 14.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

White Gloss(Ref:4.3.5.2) per QS1005 4.3-Steel

0.00



Powdercoat

Memo

START TIME:

3:15pm

OVEN TEMPERATURE:

3:45pm FINISH TIME:

400°F

0.00

⇒ 98 09/11/04

13

Ø

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

MO 09/11/05

X13

150

Identify as per dwg & Stock Location: E-tiles

0.00



Packaging

Memo

0.00

MT 09 11 09 (13)

Packaging

# Work Order ID 53124



Page 3

October 22, 2009 4:23:40 PM

Item ID: D2892-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Support

Start Date: 23/10/2009 Start Qty: 14.00



Cust Item ID:

Required Date: 30/11/2009 Req'd Qty: 14.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/09

M 09-11-9  
(13)

# Picklist Print

October 22, 2009 4:23:47 PM

Page 1

Work Order ID: 53124



Parent Item: D2892-1RevA



Parent Item Name: Support

Start Date: 23/10/2009

Required Date: 30/11/2009

Start Qty: 14.00

Required Qty: 14.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
DSK077RevA		Manufactured	No			110	Each	17.0000	7.0000			
D2892-1 TURNING DETAIL												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

17

42245

4

43386

6

43869

7

4  
3

SL 0911102

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	53124
<b>Description:</b> Ø2.500 Support		<b>Part Number:</b>	D2892-1
<b>Inspection Dwg:</b> D2892		<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.115	0.135		.130	.130	.131	.130	.131
AB	0.290	0.310		.300	.310	.310	.310	.310
AC	0.040	0.060		.049	.030	.030	.049	.049
AD	0.115	0.135		.126	.125	.125	.125	.125
AE	0.240	0.260		.251	.250	.251	.250	.249
AF	0.188	0.193		.188	.188	.188	.188	.188
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.137	1.139	1.135	1.134	1.137
AI	0.454	0.474		.466	.454	.454	.467	.467
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.257	.257	.257	.257	.257
AM	1.663	1.683		1.675	1.675	1.674	1.675	1.675
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.022	0.042		.032	.032	.032	.032	.032
AP	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AQ								
AR								
AS								
AT								
Accept/Reject								

<b>Measured by:</b>	<i>JK</i>	<b>Date:</b>	09/11/01
<b>Audited by:</b>	<i>CMR</i>	<b>Date:</b>	09/11/03
<b>Prototype Approval:</b>		<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	<i>JA</i>

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	53124
<b>Description: Ø2.500 Support</b>		<b>Part Number:</b>	D2892-1
<b>Inspection Dwg: D2892</b>	<b>Rev: A</b>	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
<b>HAAS Section</b>								
AA	0.115	0.135		.130	.130	.131	.131	.131
AB	0.290	0.310		.310	.310	.310	.310	.310
AC	0.040	0.060		.049	.050	.050	.052	.049
AD	0.115	0.135		.125	.125	.125	.125	.125
AE	0.240	0.260		.249	.250	.250	.250	.250
AF	0.188	0.193		.189	.189	.189	.187	.189
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.138	1.136	1.145	1.145	1.145
AI	0.454	0.474		.460	.460	.459	.460	.459
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.257	.257	.258	.258	.257
AM	1.663	1.683		1.673	1.674	1.673	1.670	1.670
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.022	0.042		.032	.032	.032	.032	.032
AP	2.779	2.789		2.784	2.784	2.783	2.783	2.785
AQ								
AR								
AS								
AT								
<b>Accept/Reject</b>								

**Measured by:** JL / mtf **Date:** 01/11/03

**Audited by:** mtf **Date:** 09/11/03

**Prototype Approval:** **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	53124
<b>Description: Ø2.500 Support</b>		<b>Part Number:</b>	D2892-1
<b>Inspection Dwg: D2892</b>	<b>Rev: A</b>	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	5
<b>HAAS Section</b>								
AA	0.115	0.135		.131	.130	.130		
AB	0.290	0.310		.310	.308	.308		
AC	0.040	0.060		.050	.050	.047		
AD	0.115	0.135		.125	.126	.126		
AE	0.240	0.260		.250	.251	.251		
AF	0.188	0.193		.189	.191	.191		
AG	0.240	0.260		.250	.250	.250		
AH	1.126	1.146		1.144	1.144	1.144		
AI	0.454	0.474		.459	.454	.454		
AJ	0.240	0.260		.250	.250	.250		
AK	0.053	0.073		.063	.063	.063		
AL	0.257	0.262		.257	.258	.259		
AM	1.663	1.683		1.671	1.664	1.665		
AN	0.053	0.073		.063	.063	.063		
AO	0.022	0.042		.032	.032	.032		
AP	2.779	2.789		2.785	2.783	2.783		
AQ								
AR								
AS								
AT								
<b>Accept/Reject</b>								

**Measured by:** *mmv* **Date:** 01/11/03

**Audited by:** *ang* **Date:** 09/11/03

**Prototype Approval:** **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	



SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 53124

92-1

MATERIAL: 17-4 PH STAINLESS STEEL

HEAT TREAT TO H900 CONDITION

(900°F FOR 1 HR, AIR COOL)

MIN UTS = 170 KSI (38 HRC)

IDENTIFY WITH DART LOGO (PER DART SUPPLIED

GRAPHIC) AND PART NUMBER IN THIS AREA WITH

0.125 HIGH LETTERING 0.010-0.020 DEEP

BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020

PART IS SYMMETRIC ABOUT CENTERLINE

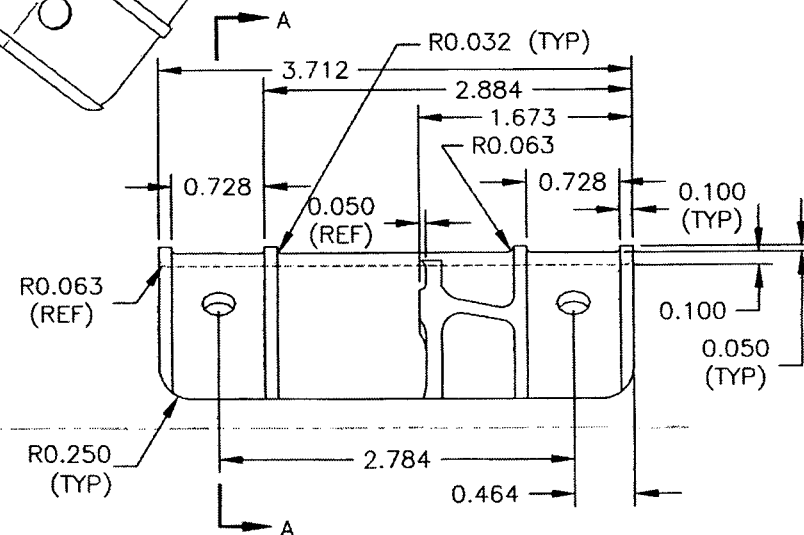
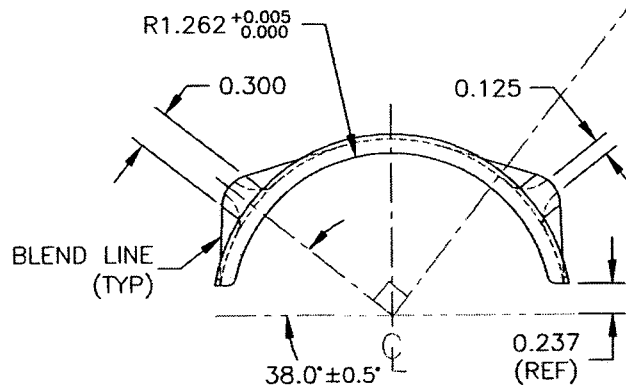
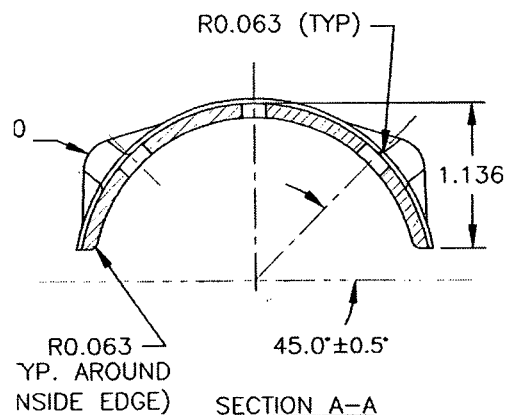
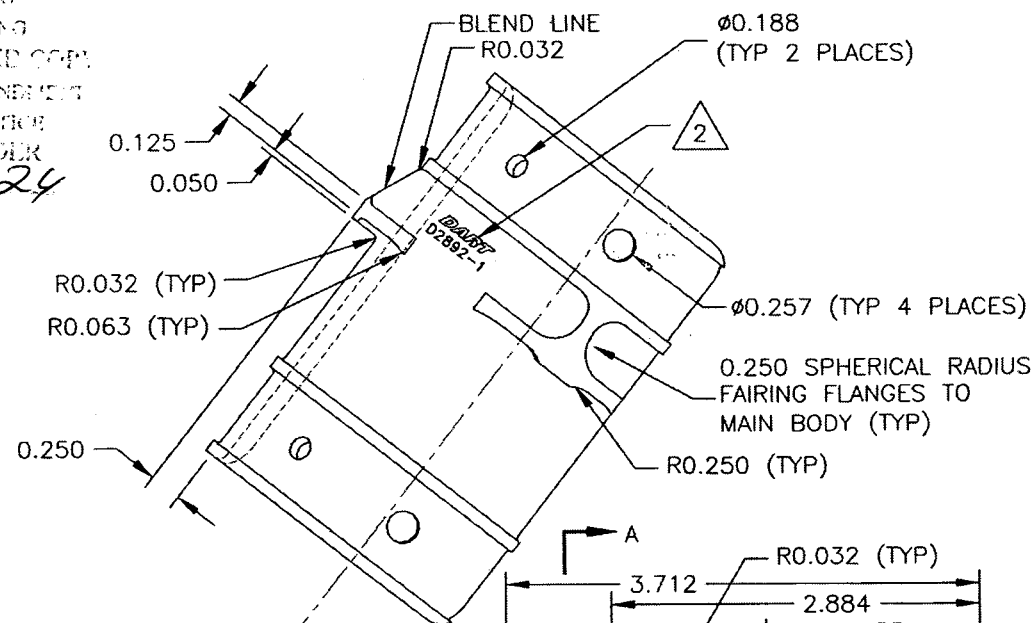
TOLERANCES ARE PER DART QSI 018 (REF.

X.XXX =  $\pm 0.010$ ) UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART

QSI 005 4.3



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A	00.11.17	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	CP	APPROVED
DATE	00.11.17	TITLE
		02.500 SUPPORT
		DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
		REV. A
		SHEET 1 OF 1
		SCALE
		1:1